

Date: Monday, 3/13/2006 7:30:16 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP SPACER		
Job Number	: 26211A					
Estimate Number	: 10375					
P.O. Number	: N/A			Part Number	: D30651	
This Issue	: 3/13/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D3065 REV. A2	
First Issue	: N/A			Project Number	: N/A	
Previous Run	: 24408A			Drawing Revision	: A2	
Written By	: See Comment below			Material	: N/A	
Checked & Approved By	: KJ 06.03.13			Due Date	: 3/30/2006	
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF			Qty:	60	Um: Each

Additional Product

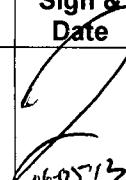
Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
		<p>Comment: Qty.: 0.1300 sf(s)/Unit Total : 7.7994 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040)</p> <p>Batch: M19295</p> <p>M 06 05 03 (60)</p>
2.0	SHEAR	
		<p>Comment: SHEAR</p> <p>Cut blank: 3.600" x 4.500" Grain along 4.500"</p> <p>M 06 05 03 (60)</p>
3.0	HAAS W.I.Jet	
		<p>Comment: HAAS CNC VERTICAL MACHINING #1</p> <p>Cut per Machine as per Folio FA182 and Dwg D3065</p> <p>Stacked 15</p> <p>Identify as D3065-1</p> <p>Prog Rev: _____</p> <p>Dwg Rev: A</p> <p>M 06 05 03 (60)</p>
4.0	QC2	
		<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p> <p>M 06 05 03 (60)</p>
5.0	QC8	
		<p>Comment: SECOND CHECK</p> <p>M 06 05 13 (56)</p>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/05/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/05/13	3	Upper bsrav. damage around hole from water jet	 	Scrap, destroy	 	06/05/13	 	 

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

HM 06/05/09

56

(60)

7.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

SB 06/06/09

56

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 06/06/09 86

9.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HM 06/06/09

56

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

Jes.06.05.09

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/06/09 56

12.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

55 06/06/09

Job Completion



U 06/06/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD	Work Order:	26211A
Description: Step Spacer	Part Number:	D3065-1
Inspection Dwg: D3065 Rev: A2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

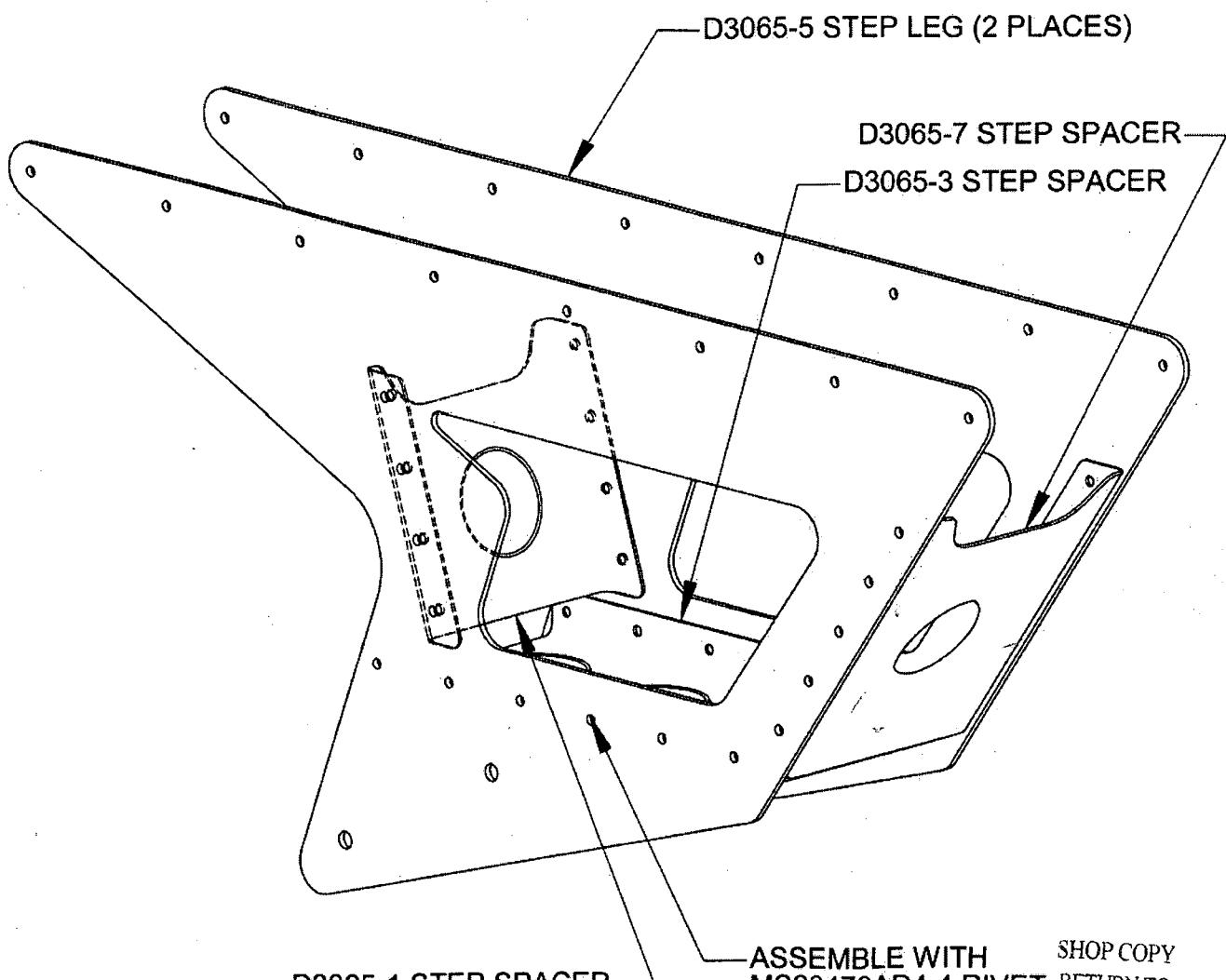
X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	06.05.03	Date:	06.05.13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	P/O D3065-041	KJ/RF <i>[Signature]</i> <i>[Signature]</i>

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. A D3065 SHEET 1 OF 5
DATE	02.09.11	TITLE SCALE STEP LEG ASSEMBLY 1:2
A	02.09.11	NEW ISSUE
A1	03.02.13 CP	ADD SLOTS TO D3065-5
A2	03.02.27 CP	0.551 WAS 0.410

RELEASED
02.09.20 CP

D3065-041 STEP LEG ASSEMBLY

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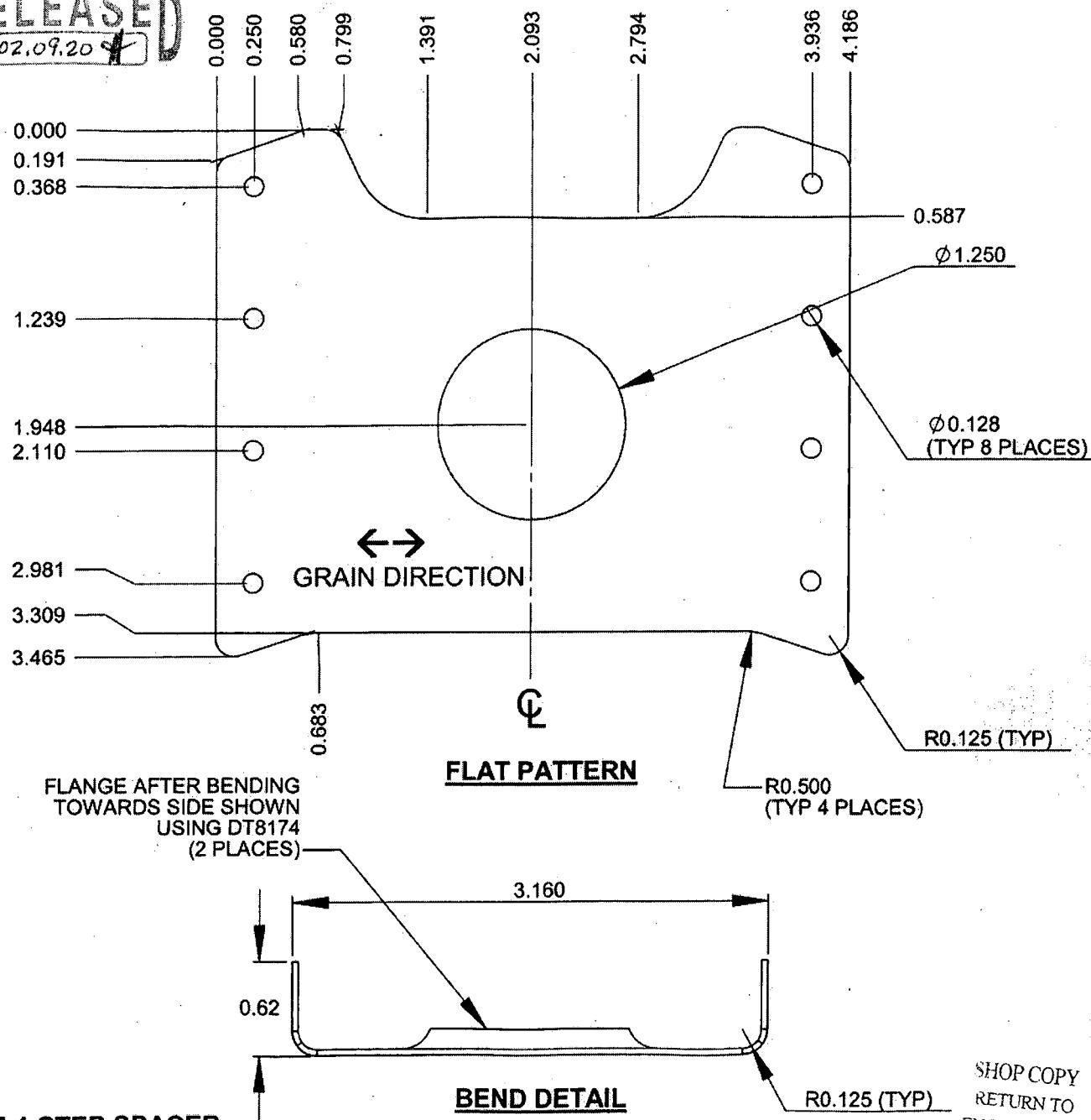


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DATE	02.09.11	TITLE STEP LEG ASSEMBLY

REV. A
SHEET 2 OF 5
SCALE
1:1

RELEASER
02.09.2011



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
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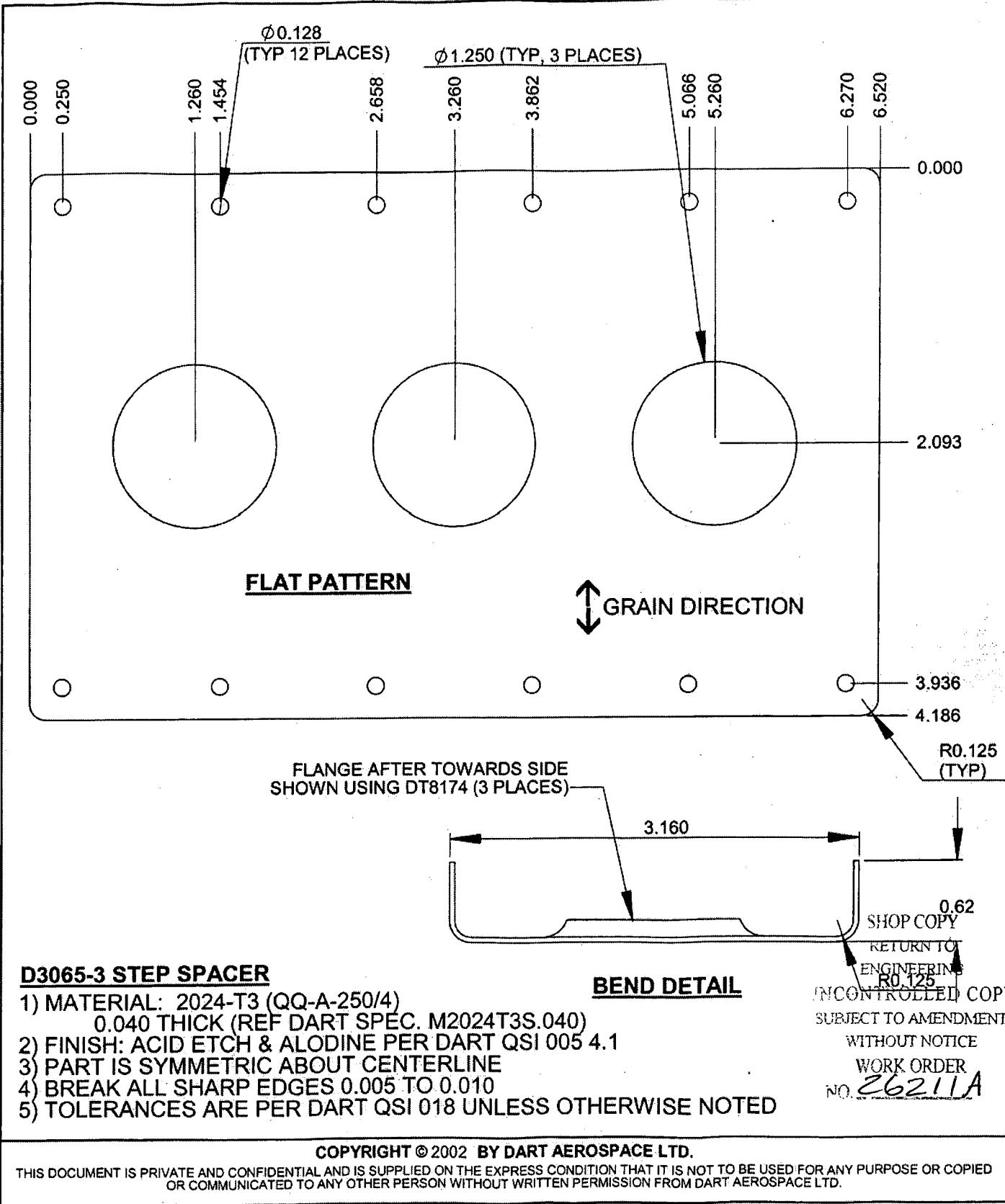
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02.09.20

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DATE	02.09.11	TITLE STEP LEG ASSEMBLY

REV. A
SHEET 3 OF 5
SCALE
1:1

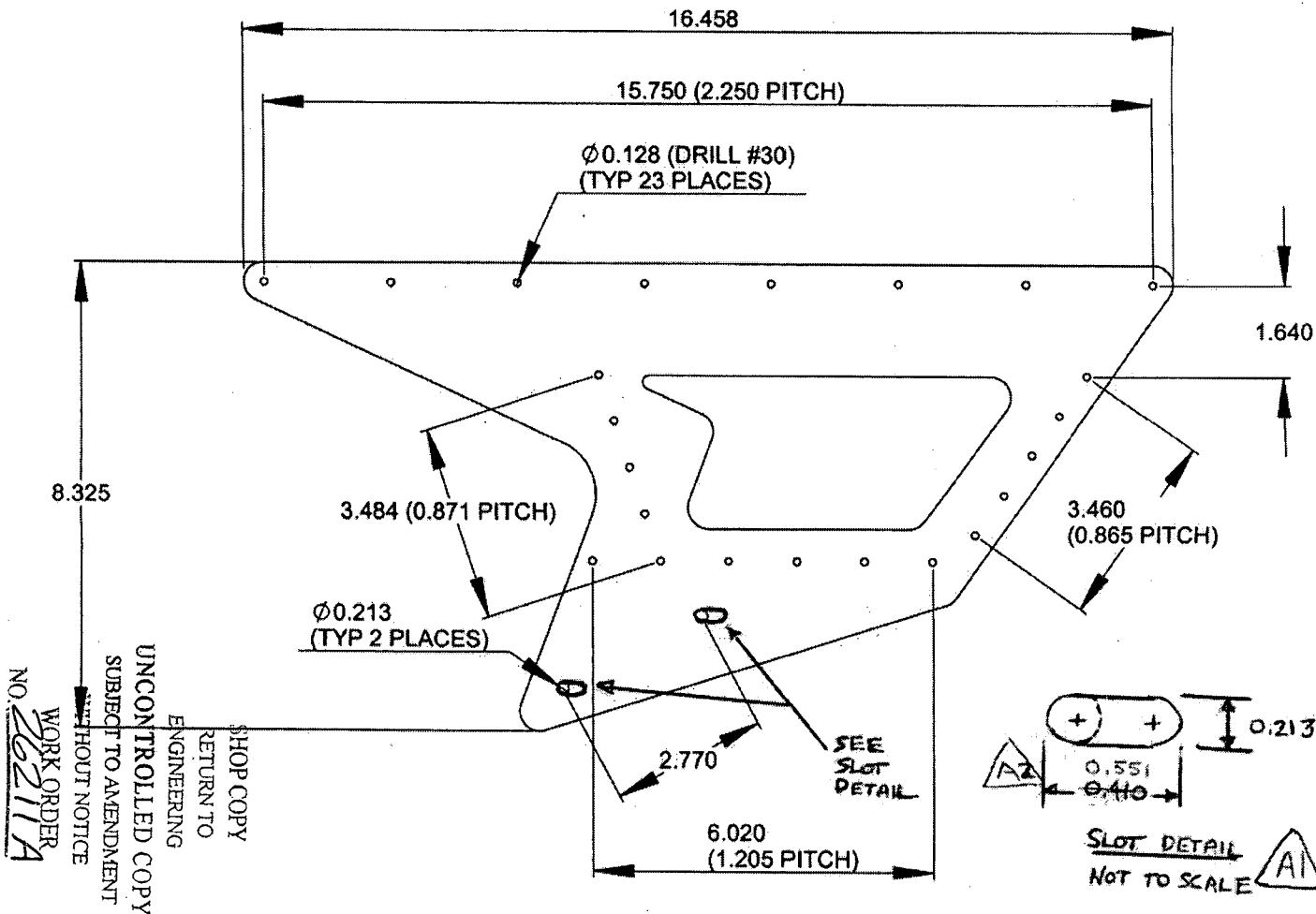


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		DRAWING NO.
		D3065
DATE	02.09.11	TITLE
		STEP LEG ASSEMBLY
		REV. A
		SHEET 4 OF 5
		SCALE
		1:3



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN

DESIGN	DRAWN BY
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DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

CHEM

CHECKED

CHECKED APPROVED

DRAWING NO.

D3065

REV A

REV. A
SWEET E OF 5

DATE

DATE

TITLE

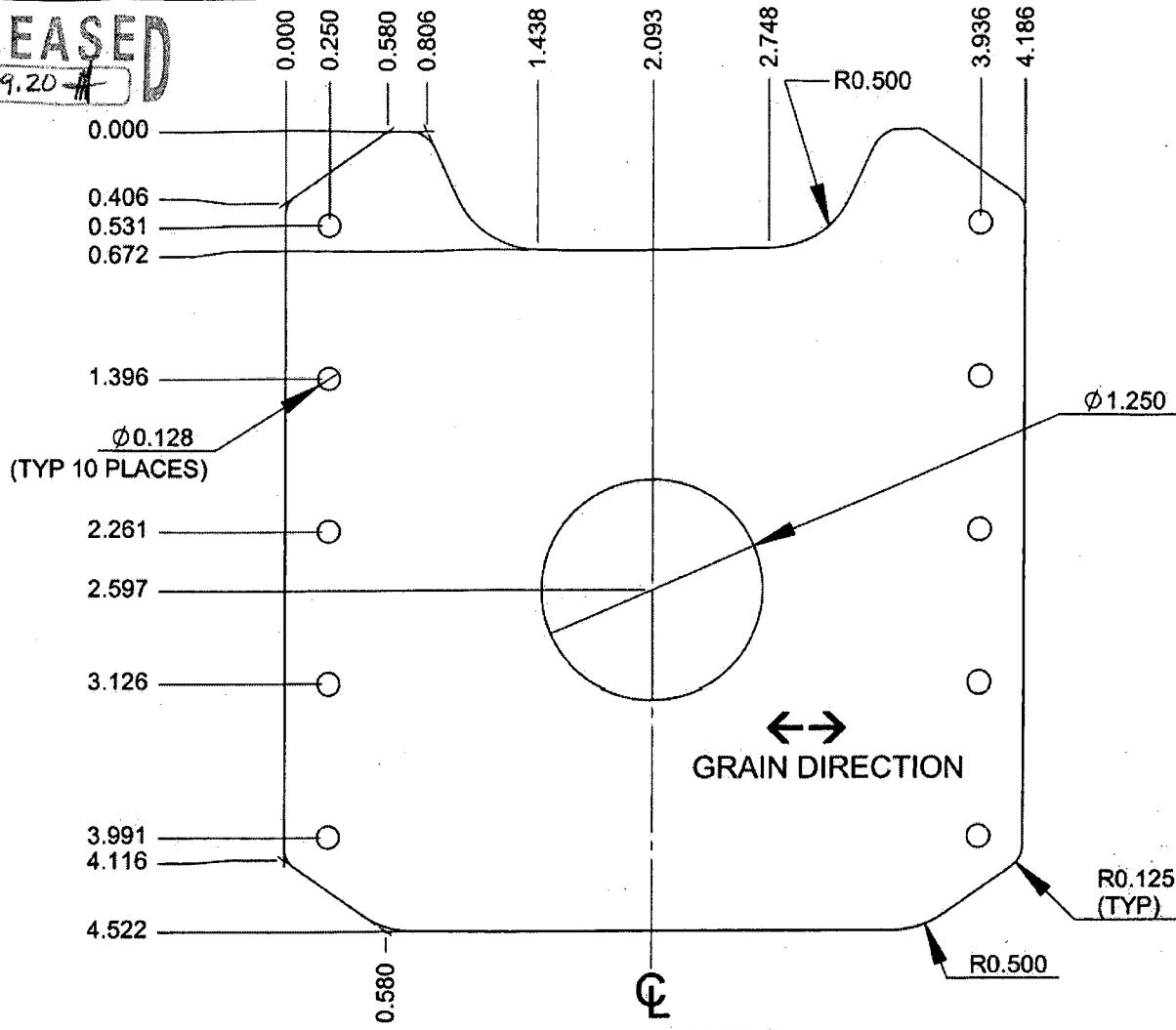
STEP 1

SCALE

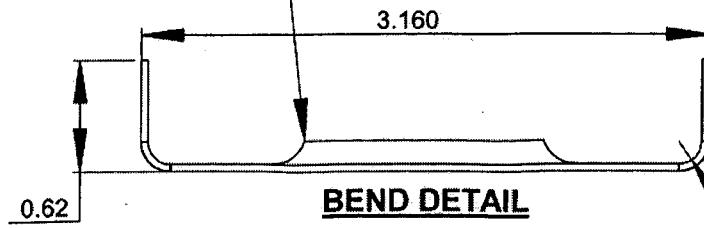
11

RELEASED
02.09.20

02.09.20 - #



**FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)**



FLAT PATTERN

BEND DETAIL

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M20)
 - 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
 - 3) PART IS SYMMETRIC ABOUT CENTERLINE
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

R-125 (REV.)
S.040
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